

Work Order ID 80325

80325

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February-17-12 8:26:48 AM

Item ID: D3512-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate
 Start Date: 17/02/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 02/03/2012 Req'd Qty: 6.00 ***6*** Customer:

Reference:

Approvals: Process Plan: M.L.J. Date: 12/02/12 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3512	Rev C

100 0.00
100 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3512 Dwg Rev: C Prog Rev: C 2-
 Deburr if necessary

M/LJ 12 02 27 (6)

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

M/LJ 12 02 27 (6)

120 0.00
120 QC8- Inspect parts - second check
 QC Memo 0.00
 Quality Control

5 12/02/28

(+6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE					(6)			
Brake NC	Memo	0.00							
Brake NC	Deburr if necessary Form as per dwg D3512 using DT8179			SB 12/03/01					
140		0.00							
140	QC5- Inspect part completeness to step on W/O					(40)			
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Large Fab					(x6)			
Large Fab	Memo	0.00							
Large Fab	Weld hard surface using DT8874 as per Dwg D3512 & QSI 004Qty								
	Description BatchA/R 2059b Hardcoat Rod								

MAL 12/03/03

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC10- Inspect visual per QSI004- ground welds 0.00

160

QC Memo 0.00

170 QC5- Inspect part completeness to step on W/O 0.00

170

QC Memo 0.00

180 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00

180

Powdercoat Memo 0.00
 Powder Coating START TIME: 4:05 320°F OVEN TEMPERATURE:
 4:35 FINISH TIME:

S.2/03/08

S.2/03/08

(16)

6 6 (16) 12/03/08

M118499

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: <u>ST 501</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

6 4 12/03/10

6x SP 12-03-12

12/3/13

12-03-13

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Picklist Print

February-17-12 8:26:52 AM

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Work Order ID: 80325

80325

Parent Item: D3512-1

D3512-1

Parent Item Name: Wearplate

Start Date: 17/02/2012

Required Date: 02/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 06-06-20 JLM
IPP Rev:B Now SS as per Rev B 06-12-15 JLM
IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

58.0000

0.261

1.648421

M304S16GA

**

12-02-27

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

58

119653

58

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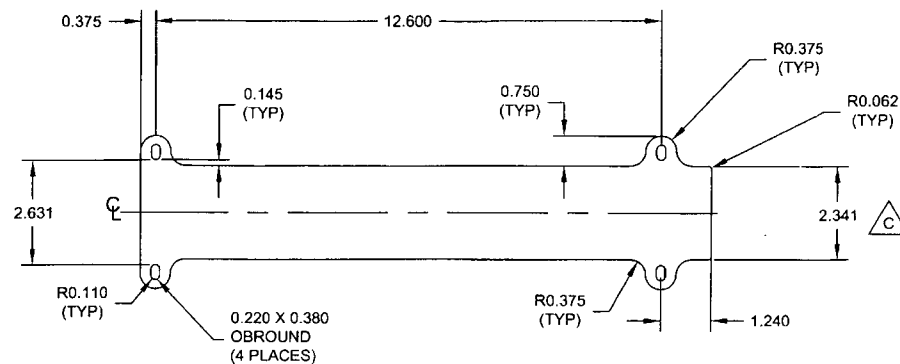
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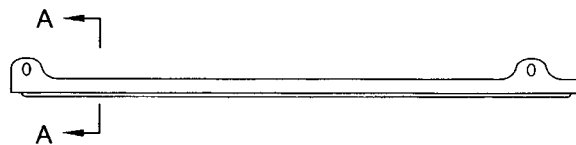
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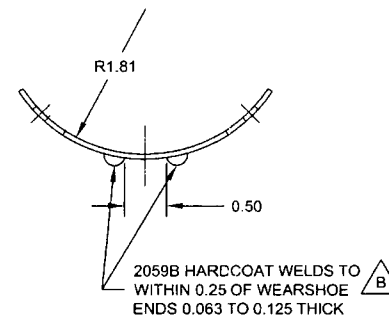
NOTE: Date & initial all entries



D3512-1F FLAT PATTERN



D3512-1 BENDING DETAIL



SECTION A-A
SCALE 2:3



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs

80325 MCT
12/02/17

RELEASED
07.11.16

C	ENLARGE OBOUNDED FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.05		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3512 REV. C
SHEET 1 OF 1

TITLE WEARPLATE SCALE 1:3

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